

Ship March 19

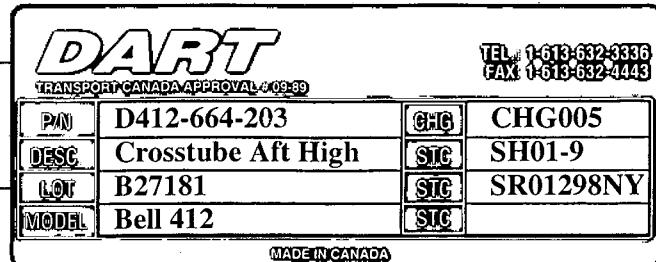
Dart Aerospace Ltd.

Date: Monday, 3/12/2007 10:57:48 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARMOR SHIELD	
Job Number	: 31162		Part Number	: D412664203A	
Estimate Number	: 12369		Drawing Number	: DSI9326	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/12/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 3/12/2007 Type : LANDING GEAR		Due Date	: 3/19/2007 Qty: 1 Um: Each	
Previous Run	: 29528				
Written By	: <i>W</i>				
Checked & Approved By	: <i>07.03.12</i>				
Comment	: Est Rev.A New Issue 06-04-19 JLM est rev. B Per ECN 886 06.12.08 EC				

Additional Product



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: Photocopy bluefile & type labels per PPP D412-664-203A CHG003 <i>07.03.12</i>		
2.0	D412664203	Crosstube Aft High
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwd Crosstube Batch: <i>27181</i> <i>ml 07/03/14</i>		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 1-Remove tube from packaging <i>M 07 03 14</i> <i>①</i>		
2-Apply Armor shield as per DSI 9326 A/R Armor Shield Batch: <i>M101241+102084</i> <i>M 07 03 16</i> <i>②</i>		
4.0	QC14	Inspect Spray Paint
Comment: Inspect Spray Paint <i>07.03.19</i> <i>③</i>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-664-203A Location: <i>BR</i> <i>07.03.19</i> <i>④</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ~~_____~~ Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARMOR SHIELD

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Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



(1)

07/03/19

Job Completion



U 07.03.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J. J.</i>	APPROVED <i>A</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105-205		
D058-676-101-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is NOT acceptable to apply Armor Shield in the cuff and support/clamp regions.

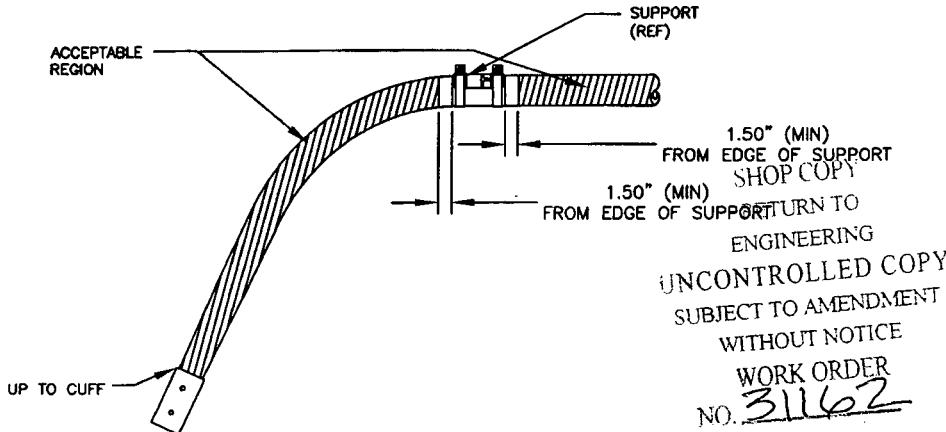
1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface
(apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>Shepherd</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.02.14
CERT. NO.:	SH03-6/SH01-9/SH01-5
ISSUE NO.:	3/3/3

FIGURE 1 – ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

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